

Work Order ID 54293-2

December 7, 2009 2:30:57 PM

Page 1

Item ID: D412-769-043

Accept

Revision ID:

Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009 Start Qty: 5.00

Required Date: 21/12/2009 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date: 08-12-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-769

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D412-769-1

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



9/12/30

DSF

SS 10/01/07

2 Sadoroz

+1
44

Work Order ID 54293

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Page 2

Item ID: D412-769-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009 Start Qty: 5.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

START 10:15
FINISH 3:20
DOWN 10:45

0.00

OK 10-01-8

①

Memo

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg
D412-769-041 12- install bolts in 3 place (in seat belt eye bolt holes) to ensure
leg does not move when Powdercoat 13- Powder coat remaining of assembly grey
as per dwg D412-769-1 START

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

OK

10-01-8

①

②

150



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

M-1 10/01/12

①

Work Order ID 54293

December 7, 2009 2:30:57 PM



Item ID: D412-769-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009 Start Qty: 5.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

Small Fab

Small Fab

Memo

1- install remaining parts as per dwg D412-769-1

0.00

0.00

M.L 10/01/12



170



QC

Quality Control

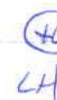
QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 5 10/01/13



180



Packaging

Packaging

Identify as per dwg & Stock Location: *1A*

Memo

FOR ASSY

0.00

0.00

10/01/13 (1)



Picklist Print

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Page 1

Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH


Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			110	Each	2,043.000	30.0000		9/12/30	SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2043

100188

188

105057

1855

AN4-15A

Purchased

No

110

Each

182.0000

10.0000



Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

182

113121

182

AN45-13A

Purchased

No

110

Each

31.0000

5.0000



EYE BOLT

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

31

109712

4

111975

27

9/12/30 SP PD

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Work Order ID: 54293



Parent Item: D412-769-043



Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-10A 		Purchased	No			110	Each	132.0000	30.0000		9/12/30	SL
Bolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	132	
107013	8	
110363	2	
112314	1	
112933	38	6
113149	50	
113255	33	

AN5-13A



Bolt

Purchased

No

110

Each

252.0000

10.0000



9/12/30 SL

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	252	
104936	3	
108167	8	
110363	14	
112492	10	
112641	17	2
113237	200	

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Work Order ID: 54293



Parent Item: D412-769-043



Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R24		Purchased	No			110	Each	146.0000	45.0000			
Screw												

M113538 9/12/30sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

146

109238

146

110

Each

1,965.000

105.0000

AN960JD10

Purchased

No



Washer

9/12/30 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1965

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

64

112314

645

112369

14

113149

1000

21

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Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

110

Each

2,311.000

20.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2311

108161

329

110523

340

111279

101

111916

482

112314

1059

16941

0

110

Each

1,016.000

100.0000

AN960JD516

Purchased

No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1016

110363

46

110523

57

111279

39

112082

64

112314

14

112828

296

113149

500

M113228
9/12/30

sl

20
9/12/30

sl

20

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Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3766-1



Front Rail, LH

Manufactured

No

110

Each

7.0000

5.0000



9/12/30

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

42872

7

110

Each

2.0000

5.0000



1

sf

D3766-3



Rear Rail

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42873

2

2

110

Each

13.0000

5.0000



B54303

1

9/12/30

sf

D3767-1



Upper Rail

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42874

48488

13

3

10

1

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Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH



Start Date: 07/12/2009

Required Date: 21/12/2009



Start Qty: 5.00

Required Qty: 5.00



Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3782-041  Front Inboard Leg Assembly		Manufactured	No			110	Each	4.0000	5.0000 			

9/12/30 sl

Warehouse Location				Loc Qty	Loc Code
Main Warehouse					
ST				4	
42839				2	
42840				2	
D3782-043  Front Outboard Leg Assembly, LH		Manufactured	No	110	Each
				3.0000	5.0000 

9/12/30 sl

Warehouse Location				Loc Qty	Loc Code
Main Warehouse					
ST				3	
46204				3	
D3782-045  Back Leg Assembly		Manufactured	No	110	Each
				4.0000	10.0000 

2

Warehouse Location				Loc Qty	Loc Code
Main Warehouse					
ST				4	
42832				2	
42833				2	

BS4328

2 SB 10/01/07



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Work Order ID: 54293



Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3783-041 		Manufactured	No			110	Each	0.0000	5.0000			
Lateral Brace Assembly D3783-043 		Manufactured	No			110	Each	0.0000	10.0000			
Longitudinal Brace Assembly D3783-045 		Manufactured	No			110	Each	4.0000	5.0000			
Angle Brace Assembly												

B54329 ① 80 10/01/05

B54330 80 10/01/05

9/12/30 sl

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4	
42852	1	
42854	2	
42855	1	

D3784-041



Seat Support Assembly, Center

Manufactured No

110 Each 4.0000 5.0000

9/12/30 sl

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4	
45879	4	

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Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH



Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3784-043  Seat Support Assembly, LH		Manufactured	No			110	Each	2.0000	5.0000 	<i>2</i>	<i>10/01/07</i>	

B 54333

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
42864	1	
42865	1	

D3784-044



Seat Support Assembly, RH

Manufactured

No

110

Each

2.0000

5.0000


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
42867	1	
42868	1	

B 54334

23 28 10/01/07

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Work Order ID: 54293



Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3



Nut

Purchased

No

110

Each

2,759.000

45.0000



9/12/30 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2759

109798

14

110844

32

111274

27

111668

194

112314

1992

112385

500

110

Each

4,135.000

10.0000



9/12/30 sf

MS21042L4



Nut

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4135

110507

184

111827

3951

15924

0

2

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Page 10

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Work Order ID: 54293



Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R22		Purchased	No			160	Each	171.0000	65.0000			
Screw												

9/12/30 sf

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

171

110139

171

160

Each

5,439.000

65.0000

13

9/12/30 sf

AN960ID10L



Washer

Purchased

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5439

101291

16

104885

153

105793

236

109632

276

110985

4758

160

Each

2.0000

5.0000

13

D3774-1



Seat Bottom, LH/RH

Manufactured

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

46065

2

13 543 11

Shop Packet Print

1x m. 10/01/12

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Work Order ID: 54293

Parent Item: D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3774-3



Seat Back, LH/RH

Manufactured

No

160

Each

2.0000

5.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 54638

46066

2

2

160

Each

31.0000

10.0000



M-L 10/01/12

1X

9/12/30

D3775-1



Guard

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42875

44532

46048

31

1

10

20

160

Each

112.0000

15.0000



2

9/12/30

D3792-1



Seat Belt Eye Bolt

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40880

41879

42020

112

17

45

50

3

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Work Order ID: 54293



Parent Item: D412-769-043



Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			160	Each	2,759.000	19 95.0000		7/12/30 SP	
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2759	
109798	14	
110844	32	
111274	27	
111668	194	
112314	1992	
112385	500	

MS21042L5



Nut

Purchased

No

160

Each

750.0000

12
60.0000



9/12/30

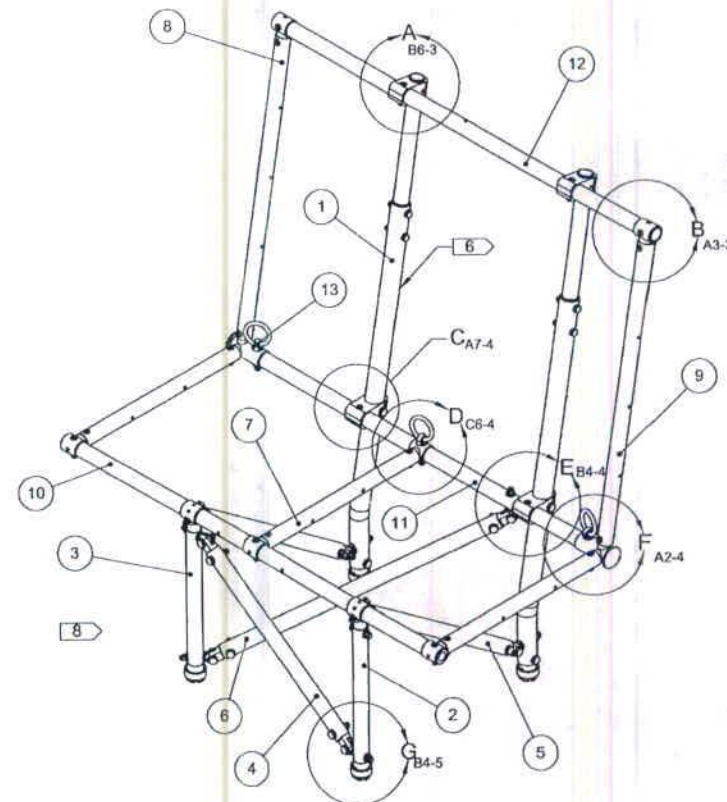
SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	750	
110382	10	
111636	11	
112314	729	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

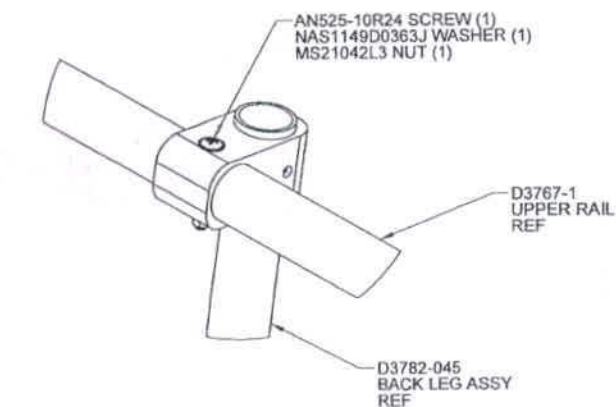
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

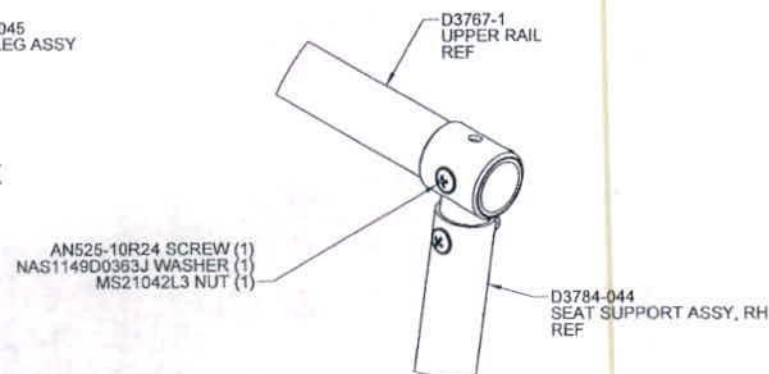


D412-769-043 AFT FACING SEAT ASSY, LH

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED FOR THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



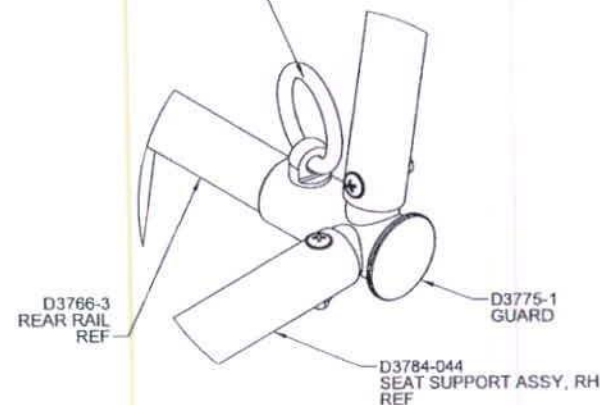
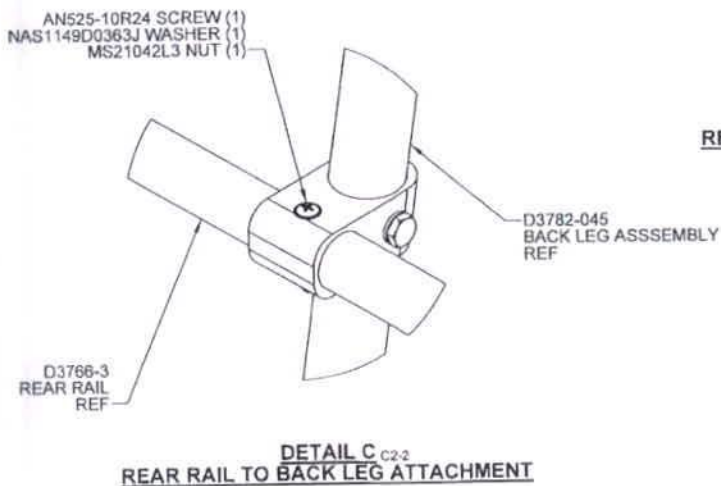
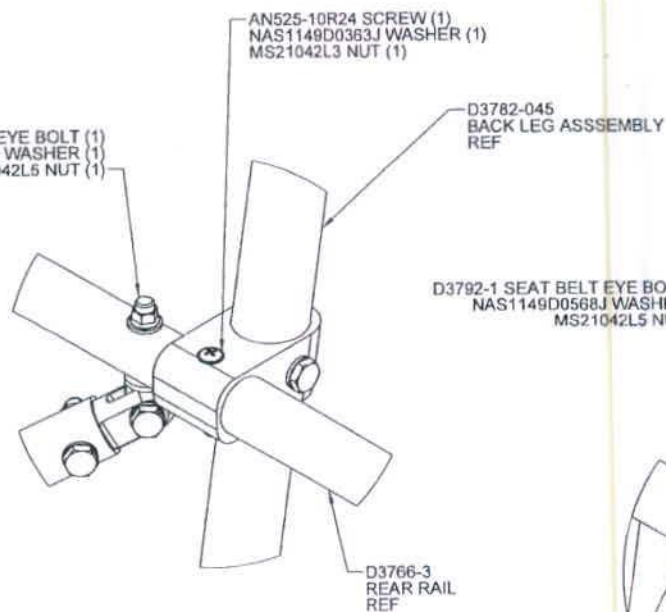
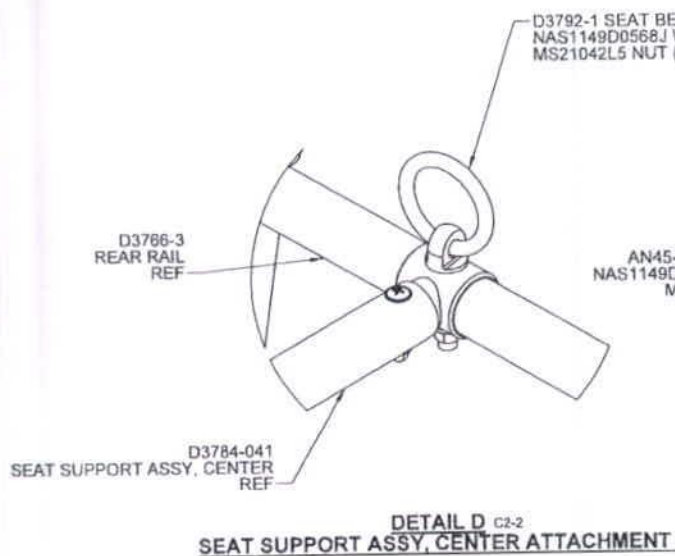
DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

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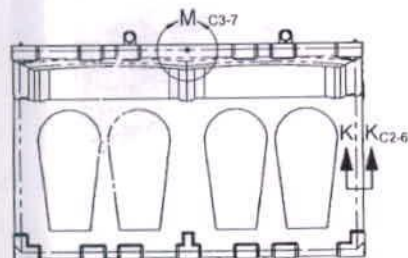




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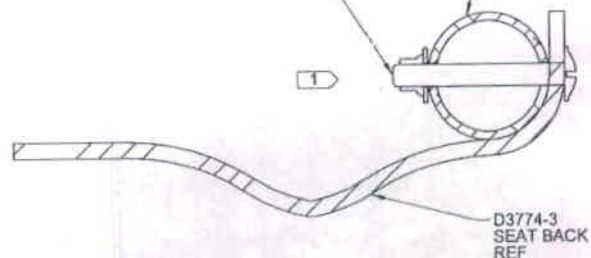


AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

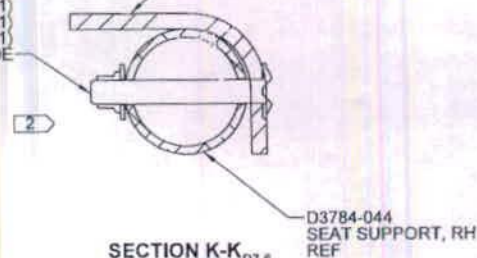
D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

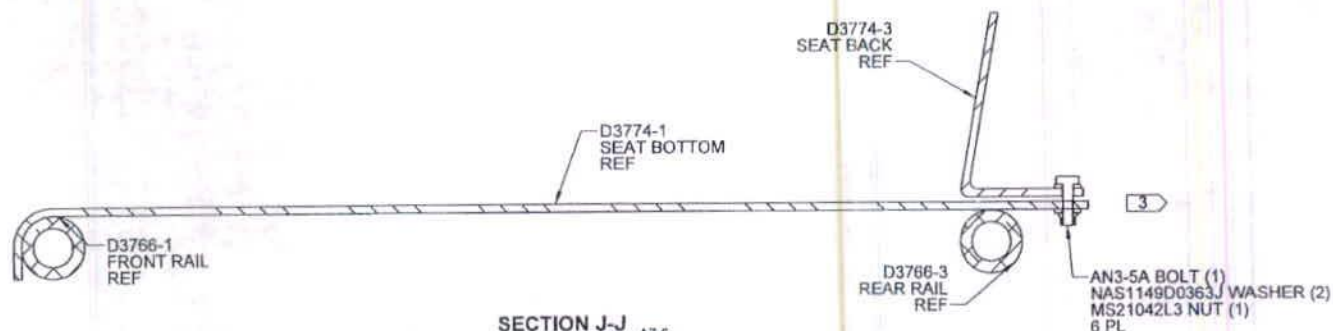
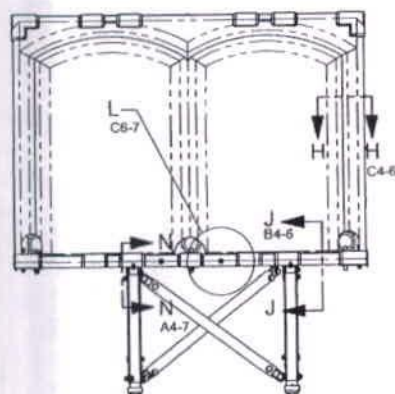
D3774-1
SEAT BOTTOM
REF



SECTION H-H B7-6



SECTION K-K D7-6



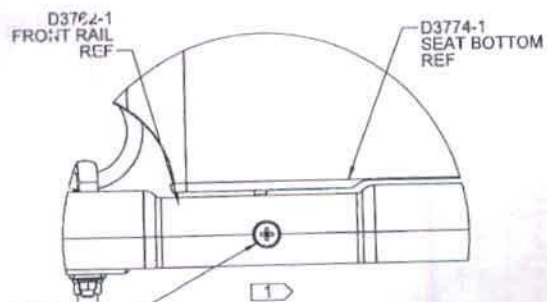
SECTION J-J A7-6

NOTES:

- 1) TRANSFER DRILL $\phi 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
- 2) TRANSFER DRILL $\phi 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
- 3) TRANSFER DRILL $\phi 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

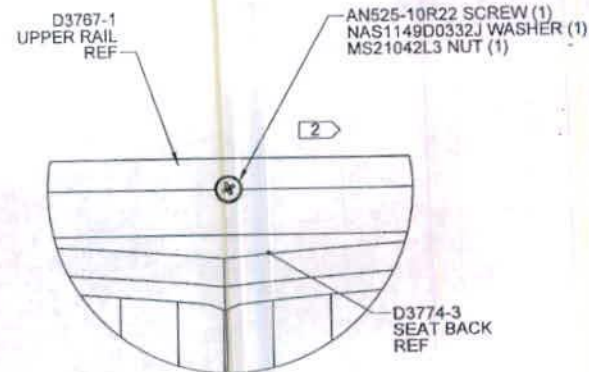
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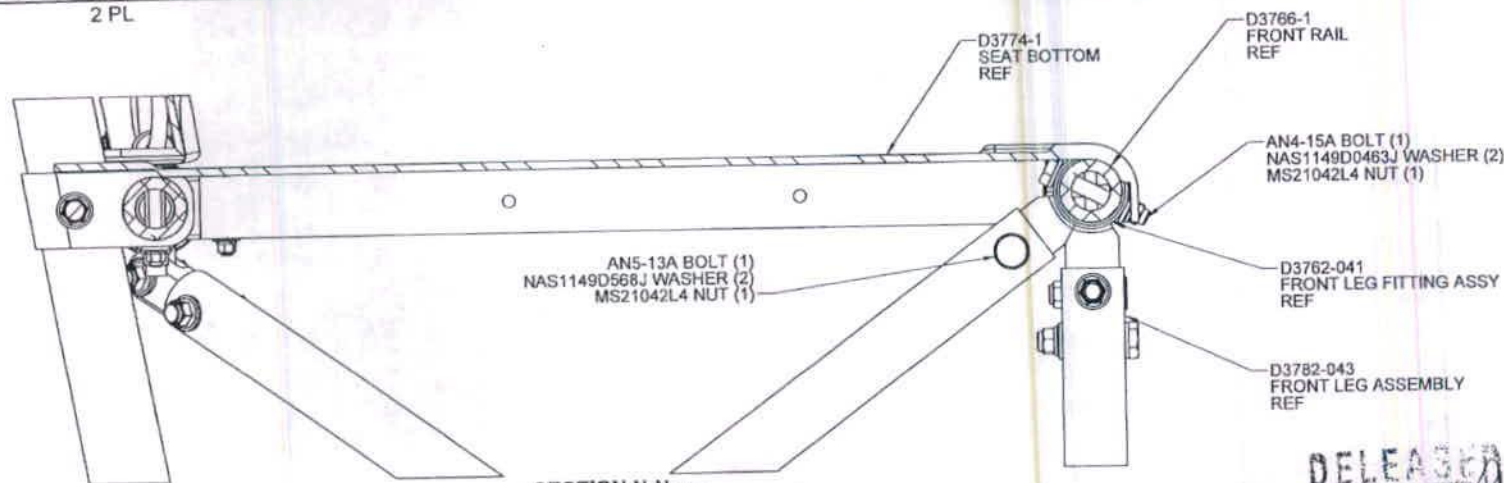


AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)

DETAIL L_{A7-6}
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M_{D7-6}
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N_{A8-6}
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

NOTES:

- 1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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